Work Order ID 99717 April-11-13 2:56:40 PM		Λ	*997	A Property of the second			Page 1				
Item ID: D23 Revision ID: Item Name: Little	360 er Tie Down Assembl	3 8	s di	Accept	*N900	<u>040</u>	100)*	Setup Sta	IV	S1* S2*
Start Date: 4/1 Required Date: 4/1 Reference:		ty: A .00 2ty: A .00	*4* *4*		Cust Item I Customer:	D:		•			
Approvals: Pr	ocess Plan: ML		Date: 13-04-15			ate:			Run Sta Sto	171	R1*
QO	C:		Date:	SPC (Y/N):	D:	ate:				* *N	R2*
Sequence ID/ Work Center ID	Operation Descript			Set Up/ A.T. Run Hours 3.t.	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2341 D2360	Rev F Rev D										
100				0.00							
1 ∩∩ Bandsaw Jeaspa Bandsaw	BAND SA	Memo Cut blanks: 12	65" Long	0.00				8_	Ø		7737-53
110	HAASCN	C VERTICAL M	1ACHINING #1	0.00				0			DAS 25 25,34-2
110 HAAS 1 HAAS CNC vertical mac		Memo	r Folio D2341 and Dwg D	0.00				<u> </u>			<u>\$-89/3-4-28</u>
HAAS CINC VERTICAL MAC		2-Deburr	FOIIO 175341 AND 19WG 17	<i>∠J</i> + I		. ·			-		Ptos

		_	
NCR:	Yes	/	No

NCR: Ye	s / No				WORK	ORDER NON-C	ONFOR	WANCE / UP	DATE	QA Closed	Date:	13/10/7	
Work Order:	9	971	7			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	(- 7	
	. Do	· · · · · · · · · · · · · · · · · · ·				Rework Scrap	1 1	Skid-tube Machining 🖈	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality	
NCR No	13	<u>30</u>	95		Wor	Use-as-is k Order Update	Theri	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root				Descri	ption of w	ork order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty	,	or Non-cor	formance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling	343	110	1	1 1	X	while		Scrapt] aby +1 Botch 896	sesty'	JL.			
Operator				mack	lining	dimension 3.285	16	at 41		13423	13/04/24		
Material	-			2 313	2 + 210	TA 3 085	ე~ § \$		a .		1307127	16 16	
Setup Other	-					JA , J. 30-4	05247	Botch 896	145			8-8-	
Process	-{			to 3.	293		L		,				
Supplier	1						13/4/24					Q>2047	
Training	1			1 1	304.	12						13/04/24	
Unapproved	1			I 493	304°	<u> </u>							
						F	AULT CATE	GORY					
Landing	Gear					General				_		_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced	
	Centre No	ot Concei	ntric to	o/s	BOM/Rot		Hardw			Over/Under	<u> </u>	Temperature/Cure	
_	Cracks				Broken/D	amaged	⊢ ⊣ `	tion Incomplete	<u> </u>	Part Incorre	 	Weld	
·	Crushed/	Crimped			Burrs			tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled	
Ŀ	Cuffs			<u> </u>	Contamina			enance	<u> </u>	Part Moved			
L	Heat Trea				Counters		Mislab		<u> </u>	Positioned V		٦	
_	Inspection		Tube		Cut Too Sl		Misrea	d	L	Power Loss/	Surge	Other	
<u> </u>	Ripples in			<u> </u>	Drill Hole	S	Offset				•	·	
_	Torque W			n _	Drawing		⊢ ⊣	Calibration					
	Turning S			<u> </u>	Finish		\vdash	Sequence					
1	Wave/Twist in Tube Folio					1 1Outsid	Outside Dimensions						

Work Order ID 9 <i>April-11-13</i> 2:56:40 PM	9717		Page 3			
Item ID: D2360 Revision ID: Item Name: Litter Tie D	Down Assembly		Accept	*N9000401	•	art *NS1* top *NS2*
Start Date: 4/11/13 Required Date: 4/11/13 Reference:	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:		
Approvals: Process QC:	Plan:	Date:	Tooling: SPC (Y/N):	Date:	•	*NR1* *NR2*
Sequence ID/ Work Center ID 150 *150* Powdercoat Powder Coating	Operation Description White Gloss(Ref:4.3.5.1) Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish	E:	32001=	Tool ID Tool #	Code Qty Qty	Number Stamp L 13/14/26
160 QC Quality Control	Memo		0.00	9 €	846	Ill 13/04(24
170 Small Fab Small Fab	Small Fab Memo Assemble as	per dwg D2360 Dril	0.00 0.00 1 # D d G 246 d G	\$1042. 5_10.01	3<	Jispiop

						·					DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	C1.					Rework	٦ ٔ		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	,					Use-as-is	1		noforming	Finishing	-	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
				1			_			-	1		·
Root		_				ption of work order update		Initial		tion	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								:					
Equip/Tooling													
Operator	_												
Material		ļ											
Setup													
Other		1											
Process	L	ļ											
Supplier													
Training													
Unapproved													
							AUI	LT CATE	GORY				
Land	ing (Gear				General		-		_	7		-
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	L	Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
i		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance		Part Moved		
		Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1	Surge	Other		

Offset

Out of Calibration

Out of Sequence Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		9717		*997				Page 2			
Item ID: Revision ID: Item Name:	D2360 Litter Tie Do	wn Assembly	ţ.	Accept	*N900	040	100)* s	Setup Star	IV	S1* S2*
Start Date: Required Date:	4/11/13 4/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D :					
Reference:		·							S4		
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:		ŀ	Run Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:	····		Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00				0	••		DAS.
120 QC		Memo		0.00				8	/_		35/3-4
Quality Control											
130		QC8- Inspect parts - seco	and check	0.00	//	/		æ			
130		Memo		0.00	X 13/04/3	24		_8			

140

0.00

140 HandFinish

0.00

Hand Finishing

Quality Control

Memo

Chemical Conversion Coat per QSI005 4.1

Memo

		_		
NCR:	Yes	/	No	

Date:

NCR: Ye	s / No				WORK ORDER NON-O	CONF	FORM	MANCE / UP	PDATE			•
										QA Closed:	Dat	te:
Work Order:	:				DISPOSITION				AGAINST [DEPARTMENT	/PROCESS	
Part No). 				Rework Scrap Use-as-is] .	. 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	—	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No).				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Ini	itial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	n QC Inspector
Doc/Data												
quip/Tooling						i						
Operator								1	•			
Material							ļ					
Setup												
Other	7							· ·				
Process								1		1.		
Supplier										Ì		
Training	7											
Unapproved	1											
			^		F	AULT	CATE	GORY				
Landing	Gear				General							
. [Bending				Bend	G	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Пн	lardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks	•			Broken/Damaged	Ir	nspecti	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped		Γ	Burrs	Ir	nstruct	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	\square	/lainte	enance	. , [Part Moved	-	
	Heat Trea	at		·	Countersink	\square	⁄liślabe	eled	·	Positioned \	Vrong	
_	Inspectio	n Strip in	Tube		Cut Too Short	\square	/lisread	ţ		Power Loss,	'Surge	Other
	Ripples in	Bend			Drill Holes	По	Offset		_			
	Torque W		extrusio	n	Drawing		of (Calibration	•			
<u> </u>	Turning S				Finish	П	ot of S	Sequence				
	Wave/Tw				Folio	——		Dimensions				

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Work Orde April-11-13 2:5					*997	717*		-	,			Page 4
Item ID: Revision ID:	D2360				Accept	*N900	040	100)* 5	Setup Start	I M	S1*
Item Name:	Litter Tie	Down Assembly				•				Stop	*N.	S2*
Start Date: Required Date: Reference:	4/11/13 4/11/13	Start Qty: 4.00 Req'd Qty: 4.00		*4* *4*		Cust Item l Customer:	D:					
Approvals:	Process	s Plan:	Date:	nul n	Tooling:	D	ate:	_	F	Run Start	*N	R1*
Approvus			_ Date:_		SPC (Y/N):		ate:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		QC5- Inspect part comp	leteness to ste	ep on W/O	0.00				A		_	04s 09
180 QC Quality Control		Memo			0.00				ග්	13-10	-73 -	. 9-89
					· .						2	ΩÃ.
190		Identify as per dwg & St	tock Location	n:	0.00				1	2/1	5 (2)	32
100 Packaging Packaging		Memo	592	121	0.00		ج _ر			3/10/62	- 9	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

200

200

Quality Control

1134-02

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	AANCE / UPD	ATE			_		
												QA Closed:	Di	ate:	
Work Orde	er.					DISPOSITION				AGAINST D	ΕP	ARTMENT	/PROCESS		
Part N NĆR N	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Actio	on	Τ	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descrip	otion		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							A 11	T CATE	CORV						
***							AUI	LT CATE	JORY				,		
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	on Incomplete ions Incomplete/Ur nance led	nclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
N.	1	Inspectio	n anih in	Tube	<u> </u>	Cut Too Short Misread			1		յ՝	LOME! FO22	Juige	L'	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

April-11-13 2:56:38 PM

Work Order ID:

99717

Parent Item:

D2360

Parent Item Name:

Litter Tie Down Assembly

Start Date: 4/11/13

Required Date: 4/11/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP rev H 07.06.12	ecn 825 EC											 ,
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	4	1303	/10	101
				Location		Loc Qty	<u>L</u>	oc Code				//	
	,	,		FP001		93							
				45	523	93							
				ST346		500				-			
)8079 	400				<u> </u>			,
M-200	NAG1140D02625		M-	11	0099	100	Each	0.0000			/2/	_ /	
AN960JD10 Washer	NAS1149D03632	4397 GC	No			170	Each	0.0000	2	8		3/DC	101
AN960JD10L	NAS1149D0332J	Purchased	No			170	Each	0.0000	8	32/	2/17	//0/	
Washer D2002-015	Ð	MI25807 Manufactured	No			170	Each	45.0000	2	8	P 1		/
Knob		Manufactured									J3	1,01	100
	-			Location		Loc Qty	<u>L</u>	oc Code					
	•			GA		45			***************************************	_//			
					3241	20					12 1		/ /
¿. D2345			No	98	3570	25 170	Each	11.0000	1	<u> </u>	9/1	/.	
Lock Channel		Manufactured	INO		*	170	Each	11.0000	, I	4 (/9 / (-	7/00	0/01
				<u>Location</u>		Loc Oty	<u>L</u>	oc Code			R996	261	20
				GA		11					DIM		
				86	5349	11					5,000	900) (
D2366		Manufactured	No			170	Each	12.0000	2	8<	1/3	101	01
Lock Handle							_	6 1					
				Location		Loc Oty	<u>I.</u>	oc Code					
				ST009	(251	12					R 11	028	29
. %					5351 5770	2 10					PO		-/
				,2.	2.10	10						6	

.

	DQA:	Date:
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE		- W
QA	Closed:	Date:
Work Order: DISPOSITION AGAINST DEPAR	TMENT/PROCES	S
Rework Skid-tube Crosstube	Water	Jet Engineering
Part No. Scrap Machining Small Fab	Prod. Eng. Co	
	Rec/Store/Packag	— ·—
NCR No. Work Order Update Large Fab Composite	Supp	' '
Root Description of work order update Initial Action Si	ign &	
Cause Date Step Qty or Non-conformance Chief Eng Description I	Date Verific	ation QC Inspector
Doc/Data Doc/Data		
Equip/Tooling Equip/Tooling		
Operator		
Material	-	
Setup Setup		
Other	1	
Process		
Supplier		
Training		
Unapproved		
FAULT CATEGORY		
Landing Gear General Bending Bend Grain Ova	alized	Pressure/Forced
	er/Under tolerance	
	t Incorrect	Weld
	t Lost/Missing	Wrong Stock Pulled
	t Moved	
1 (Cuita Cuitatimation Internation Int		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio April-11-13 2:56:39 PM

Work Order ID:	99717				A STATE OF THE PARTY OF THE PAR				
Parent Item:	D2360				•		Start	Date: 4/11/13	Required Date: 4/11/13
Parent Item Name:	Litter Tie Down Assembly						Star	t Qty: 4.00	Required Qty: 4.00
D2367 Handle Knob	Manufactured	No			170	Each	23.0000	I constitution of the state of	1 Sis /10/01
			Location		Loc Qty		Loc Code		
			ST009		23				<u></u>
	•		89083 95711		3 20			_3	
D2372 Quick Release	Manufactured	No			170	Each	19.0000	2	8 Sis /10/01
	e e		Location		Loc Oty		Loc Code		
			GA		19				B99810
			86001		2				_ 2(1010 (4)
			95177		5				_
			97848		12				- 0a 11
D2373 Spring	Manufactured	No			170	Each	9.0000	1	4 6/5/3/10/01
			Location		Loc Oty		Loc Code		1 PSQ 21/1 (2)
			ST009		9				B98341 30
			86352		9				
D2444 Pip Pin Assembly	Manufactured	No			170	Each	12.0000	1	15/10/01
			Location		Loc Qty		Loc Code		B105573(2)
			ST010		12				P103 3 P3 (42)
			97238		1				
			98455		11			***************************************	<u> </u>
D6201 "T" Extrusion	Manufactured	No ·			100	, f	57.9186	1.054 4.4	1378948 SL 13-4-23
			Location		Loc Oty		Loc Code		
			MAT028	5	7.91863153				
			81421		4.61863153				
	·		83987		20				
			89645		13.3			x 8 .9	_
			96808		20				

									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	CONFORM	MANCE / UPDATE		QA Closed:	Date:	
Work Order	·•		-		DISPOSITION		AGA	INST DEF	PARTMENT	/PROCESS	
	-				Rework	1	Skid-tube Cross	tube		Water Jet	Engineering
Part No).				Scrap	1 1	├ ─-	I Fab	Pro	d. Eng. Coor.	Quality
	•				Use-as-is	1 1	→	shing		re/Packaging	Other
NCR No	o.				Work Order Update	1 I	Large Fab Comp	~	•	Supplier	
	•					·					
Root				Descri	ption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspect
Doc/Data											
Equip/Tooling											
Operator		1									

DOA

QC Inspector

FAULT CATEGORY Landing Gear General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Maintenance Cuffs Contamination Positioned Wrong Mislabeled Countersink Heat Treat Power Loss/Surge Other Inspection Strip in Tube Misread Cut Too Short Ripples in Bend Drill Holes Offset Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Finish Turning Sequence Folio Outside Dimensions Wave/Twist in Tube

Material Setup Other Process Supplier Training Unapproved April-11-13 2:56:39 PM

Work Order ID:	99717					et.		_		
Parent Item:	D2360					÷			ate: 4/11/13	Required Date: 4/11/13
Parent Item Name:	Litter Tie Down As	ssembly						Start (Qty: 4.00	Required Qty: 4.00
MS20470AD3-4 Rivet,Universal Head		Purchased	No	٠		170	Each	8,512.0000	1	1 3/10/01
,				Location	n	Loc Qty		Loc Code		
				GA		180				
•	e e				15541	180			•	-
				ST319		8332				_
		•		0.017	111477	8332			3	
MS21042L3		Purchased	No			170	Each	4,881.0000	3	12
Nut		i di chased								900/10/01
•				Location	n	Loc Qty		Loc Code		
				FP001		3				
				11001	122141	3				<u>-</u>
				GA		119				_
					122452	119				
				ST314		268				
					117885	32	•			
					119017	55				
					119075	138				nice.
					123265	43				_
				ST506		4491				_
					123900	976				- //
					124291	3515				- V/ //
MS27039-1-13 Screw		Purchased	No			170	Each	550.0000	1	4 9 3/0/01
		•		Location	<u>n</u> .	Loc Qty		Loc Code		
				GA		2	·			<u>/</u>
					119736	2			<u> </u>	_
				ST304		48			?	_
					119736 🗕	48			- B	
•				ST506		500				
					124326	500				
			2							

**							DQA:	Date	e:
NCR: Yes / No		WORK ORDER NON-	COI	NFORN	MANCE / UPDATE				
					-		QA Closed:	Date	e:
Work Order:		DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Order.		Rework	7		Skid-tube Crosstube		1	Water Jet	Engineering
Part No.		Scrap	1		Machining Small Fab		Pro	d. Eng. Coor.	Quality
		Use-as-is	1		oforming Finishing	-	-∔	e/Packaging	Other
NCR No.		Work Order Update	1		Large Fab Composite		1	Supplier	
-									
Root		iption of work order update	1	nitial	Action		Sign &		
Cause Date Step	Qty	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling							·		
Operator									
Material				1					
Setup									
Other							ļ		
Process									
Supplier			1						
Training		- ,	1	1					
Unapproved				T CATE	CORV				
Landing Cons		General	AUL	T CATE	JUKY				
Landing Gear		Bend		Grain		Γ	Ovalized	Г	Pressure/Forced
Bending Centre Not Concent	ris to O/S	BOM/Route	-	Hardwa	,	\vdash	Over/Under	tolorance	Temperature/Cure
Cracks	hc to 0/3	Broken/Damaged	-	4	on Incomplete	\vdash	Part Incorred	-	Weld
Crushed/Crimped	-	Burrs	\vdash	1 '	ons Incomplete/Unclear	\vdash	Part Lost/Mi	}	Wrong Stock Pulled
Cuffs	<u> </u>	- Dui 13	-	1	· ·	\vdash	-	231116	
I Icuiis	ı	Contamination		Mainte	nance	1	Part Moved		

Misread

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-11-13 2:56:39 PM

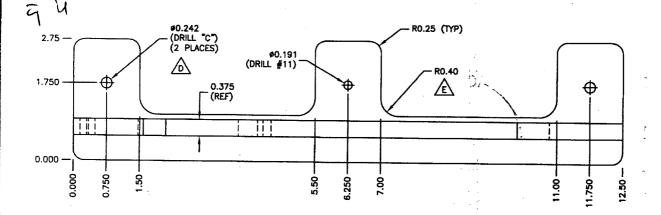
Work Order ID:	99717				
Parent Item:	D2360			Start Date: 4/11/13	Required Date: 4/11/13
Parent Item Name:	Litter Tie Down Assembly			Start Qty: 4.00	Required Qty: 4.00
MS27039-1-15 Screw	· Purchased	No	170 Each	967.0000 2	8/5/13/10/01
		Location	Loc Oty	Loc Code	
		ST506	967		
•		124326	967	<u></u>	- 2. 1.1
NAS679A3W Nut	Purchased	No	170 Each	174.0000 1	4 Sis /0 /0/
		Location	Loc Oty	Loc Code	
		GA	5		\angle MILLULT
		1463	5	<u>-</u>	
		2409	169		

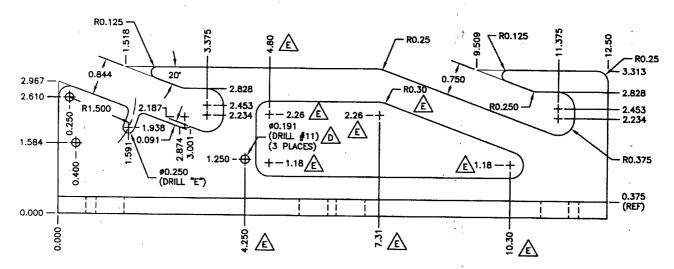
		DQA:	Date:	· ,
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date	::				
Work Orde	or.				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part N	Part No				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
		,	,			لـــــ										
Root					ption of work order update	1	nitial		ction	Sign &	_					
Cause	Date	Step	Qty	- (or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector				
Doc/Data																
Equip/Tooling																
Operator																
Material										,						
Setup																
Other					•	1										
Process																
Supplier		İ														
Training										ļ						
Unapproved		L]										
					······································	AUL	CATE	GORY		·-····						
Landir	ng Gear				General					1	Г	-				
	Bending			<u> </u>	Bend	\vdash	Grain		<u> </u>	Ovalized	-	Pressure/Forced				
	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa		_	Over/Under	<u> </u>	Temperature/Cure				
	Cracks			ļ	Broken/Damaged	\vdash		on Incomplete	_	Part Incorre	⊢	Weld				
	Crushed/	Crimped		<u> </u>	Burrs	-		ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled				
	Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved						
	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		_				
	Inspectio	-	Tube	<u> </u>	Cut Too Short	-	Misread	d	Ľ	Power Loss/	Surge	Other				
	Ripples in			<u></u>	Drill Holes -	-	Offset									
	Torque W	Vaves in E	Extrusio	n <u> </u>	Drawing	-		Calibration								
	Turning S	equence			Finish		Out of S	Sequence								
	Wave/Tu	ist in Tul	he		Folio	1 1	Outside	Dimensions								



DESIG	W	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHEC	KED 2	APPROVED	DRAWING NO. REV. F							
	<u> - 49 </u>	744	D2341 SHEET 1 OF 1							
DATE			TITLE SCALE							
07.0	06.07		LITTER TIE DOWN BRACKET (LOCKING) 1:2							
A		95.01.13	NEW ISSUE							
В		95.02.14	MODIFIED LOCK							
D		95.02.20	CHANGES TO DIAMETERS							
E		97.10.01	CHANGES FOR MACHINING							
F		07.06.07	REVISED NOTES; FINISH WAS ANODIZE							





- D2341 LITTER TE DOWN BRACKET (LOCKING)

 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
 (6061-T6/T651 PER QQ-A-200/8)

 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

 3) BREAK ALL SHAPP EDGES TO 0.005 TO 0.010
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER



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DESIG	BW	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHEC	(ED	APPROVED,	DRAWING NO. REV. D						
	E	- AF	D2360 SHEET 1 OF 2						
DATE			TITLE SCALE						
07.0	06.06 ⁻		LITTER TIE DOWN ASSEMBLY (LOCKING) NTS						
Α		95.02.10	NEW ISSUE						
В		95.02.20	RE-DESIGN						
С		97.08.27	ADD MS20470AD3-4 RIVET						
D		07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)						

RELEASED

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
Х	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT
		12



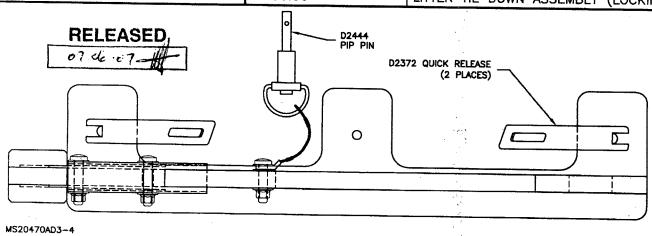


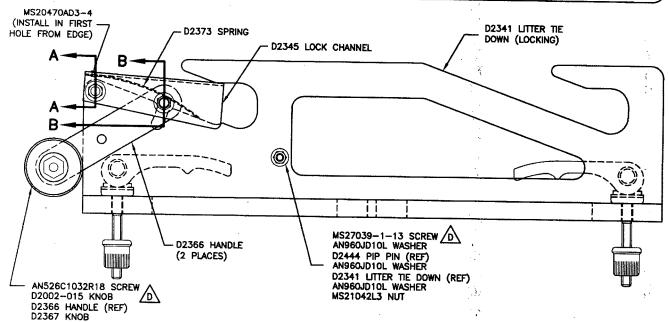


D2366 HANDLE (REF) D2002-015 KNOB

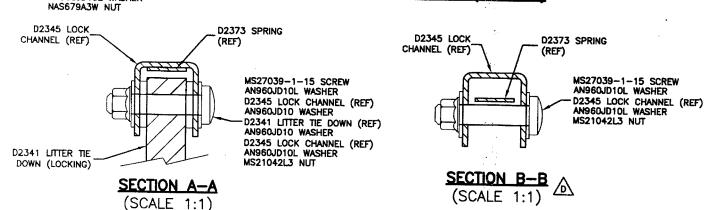
AN960JD10L WASHER

DESIGN DRAWN BY DART AEROSPACE LTD BW HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. REV. D D2360 SHEET 2 OF 2 DATE TITLE SCALE 07.06.06 LITTER TIE DOWN ASSEMBLY (LOCKING) NTS





D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



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DART AEROSPACE LTD	Work Order:	
Description: Litter Tie Down Bracket (Locking)	Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Totalogo	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
1.750	+/-0.010	1744			Noch	21-10
2.75	+/-0.030	2.755				
Ø0.242	+0.005/-0.001	242			~	
Ø0.191	+0.005/-0.001	191			~	
R0.25	+/-0.030	250	/			
R0.40	+/-0.030	.400	/_			
12.50	+/-0.030	12.505			H-G	
11.750	+/-0.010	11.750			Vecn	CNC-09
11.00	+/-0.030	11.003			HG	
7.00	+/-0.030	7-004			N-G	
6.250	+/-0.010	6.251			wrn	CUC-a)
5.50	+/-0.030	5.503			HG	
1.50	+/-0.030	1.505			vern	JL-10
0.750	+/-0.010	753			١,	
0.400	+/-0.010	400			bas.	
1.584	+/-0.010	1584			<i>-</i>	
2.610	+/-0.010	2-610			~	
0.250	+/-0.010	249			55	
0.844	+/-0.010	2844			~	
Ø0.250	+/-0.010	251				
0.750	+/-0.010	751			n	
3.313	+/-0.010	3,314			••	
4.250	+/-0.010	4-250			~	
1.250	+/-0.010	1-249				

Measured by:	Audited by:	ont	Prototype Approval:	N/A
Date: 13-4-23	Date:	13/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.05.24	New Issue P/O D2360	KJ/JLM	
В	07.07.17 Dwg Rev. updated		KJ/JLM , A	11
С	10.02.02	Dimensions updated	KJ 📢	BN.